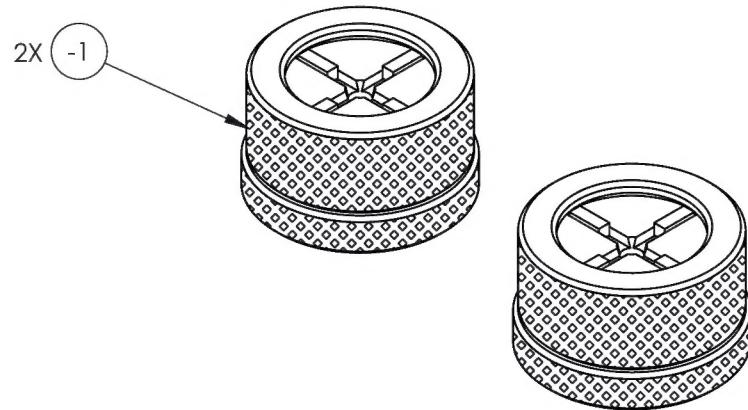


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REVISIONS							
REV	ECR	DESCRIPTION			DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.			10/10/2016	DPD	JAG



NOTES:

1. REF. EUROCOPTER T/N: 105-40001W1.
2. USED ON MODELS:
EC135, EC145, EC635, EC645, H135.

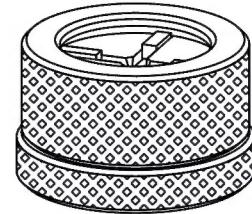
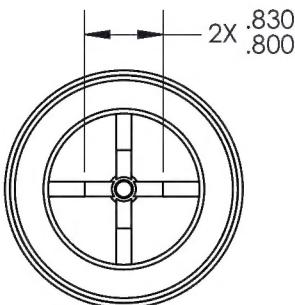
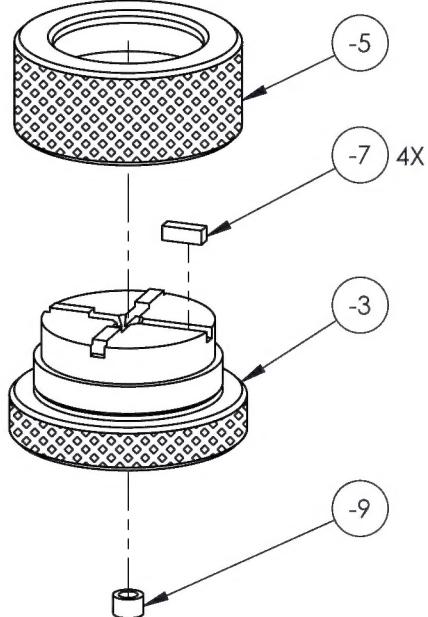


TITLE		REV
DWG NO.		1
	RBE105-40001W1	
MAT'L	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8	
FINISH	.XX ± .01 ANGLES ± 5°	
SPEC	X ± .1 SURFACES = 125 ✓	
DRAWN BY:	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
CHECKED:	2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
OPPS APPR:	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
QA APPR:	USED ON MODEL LINDSAY	
APPROVED:	SEE NOTE 2 GILBERT	
SCALE	1:2	DATE 1/19/2016
		SHEET 1 OF 6

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1	2	STAKING TOOL RETAINER ASSEMBLY			2
1			-3		BASE	4140/4142		3
1			-5		RETAINING RING	4140/4142		4
4			-7		SLIDING PAD	S.S.	4mm X 4mm X 12" (MCMASTER-CARR #90457A420) MODIFIED	5
1			-9		INSERT	NYLON		6
		B/O	-11	1	PISTOL CASE	PLASTIC	RSR GROUP #10137	N/S
	ASSY -1							

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REV	ECR	REVISIONS	DESCRIPTION	DATE	INITIAL	APPROVED
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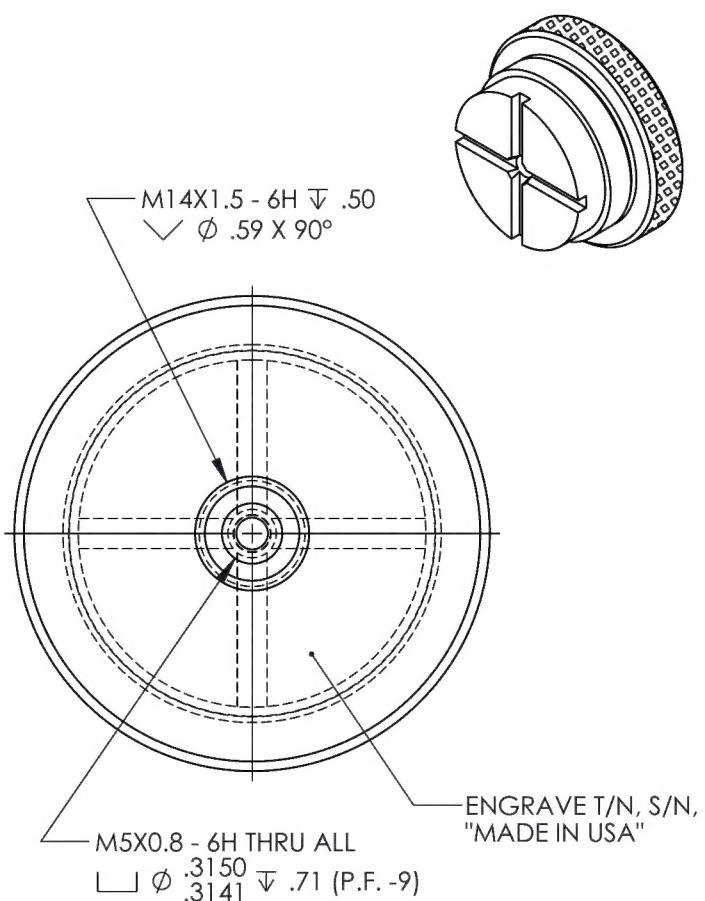
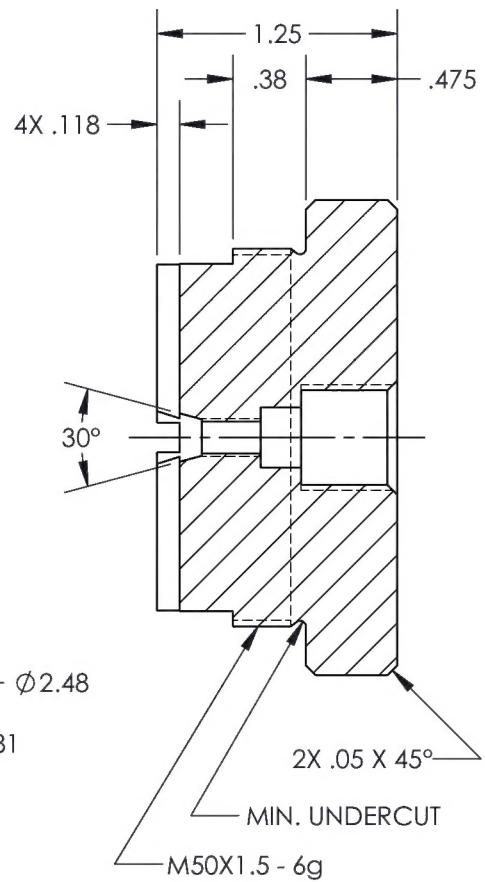
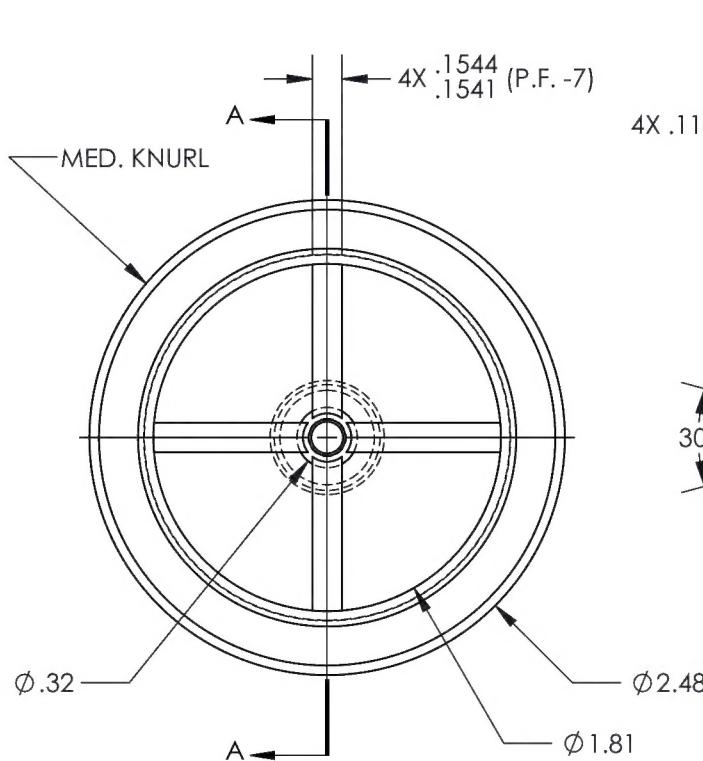
(-1)

STAKING TOOL RETAINER ASSEMBLY

DART AEROSPACE	
TITLE	
STAKING TOOL RETAINER	
DWG NO.	
RBE105-40001W1-1	
REV	
1	
MATERIAL	
HEAT	
TREAT	
FINISH	
SPEC	
DRAWN BY: DUERFELDT	
CHECKED: CLOUGH	
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° X ± .1 SURFACES = 125 ✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
USED ON MODEL	
SEE SHEET 1 NOTE 2	
SCALE	1:2
DATE	1/19/2016
SHEET 2 OF 6	

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REV		ECR		DESCRIPTION		DATE	INITIAL	APPROVED
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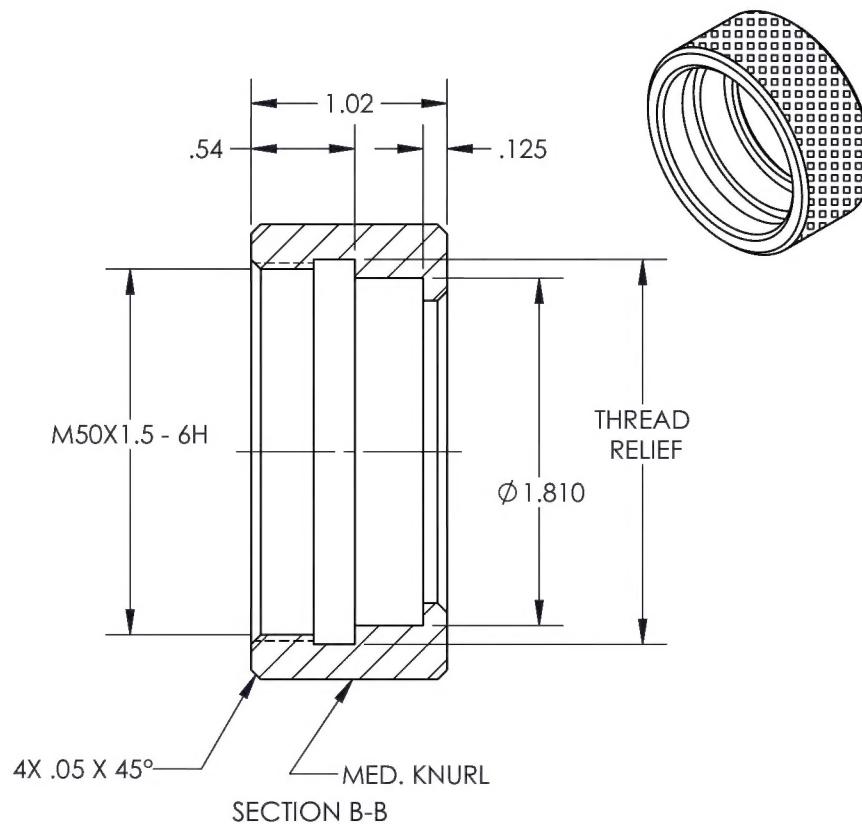
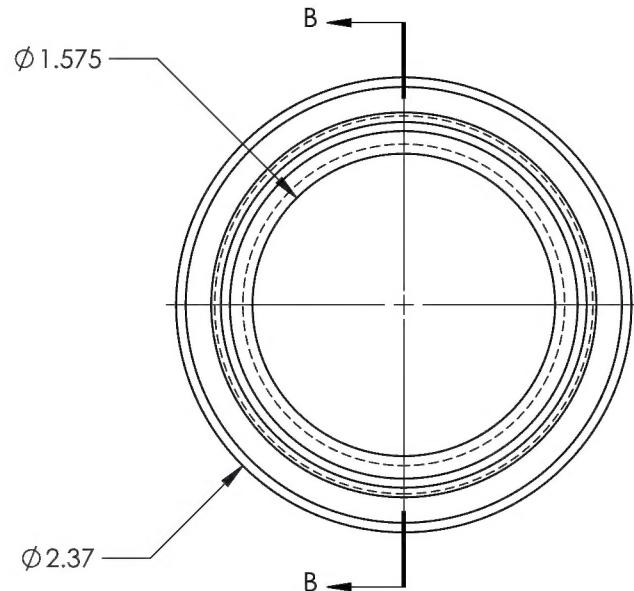
(-3)

BASE

	
TITLE STAKING TOOL RETAINER	
DWG NO.	RBE105-40001W1-3
REV	1
MAT'L	4140/4142
HEAT	RC 45-50
TREAT	
FINISH	ZINC PLATE
SPEC	ASTM B633 TYPE I SC 2
DRAWN BY:	DUERFELDT
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
UNLESS OTHERWISE SPECIFIED	
DIMENSIONS ARE IN INCHES	
.XXX ± .005	FRACTIONS ± 1/8
.XX ± .01	ANGLES ± 5°
X ± .1	SURFACES = 125
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
USED ON MODEL	
SEE SHEET 1 NOTE 2	
SCALE	1:1
DATE	1/19/2016
SHEET 3 OF 6	

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REV	ECR	REVISIONS	DESCRIPTION	DATE	INITIAL	APPROVED
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SECTION B-B

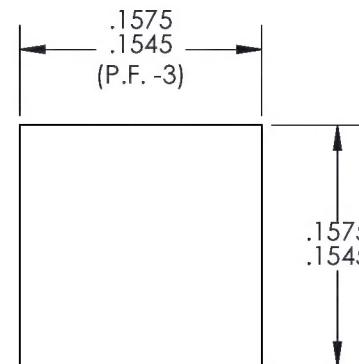
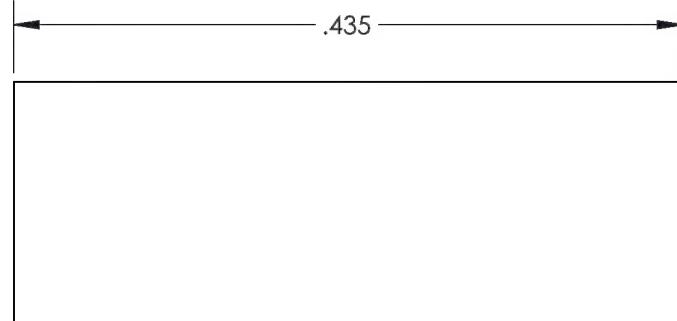
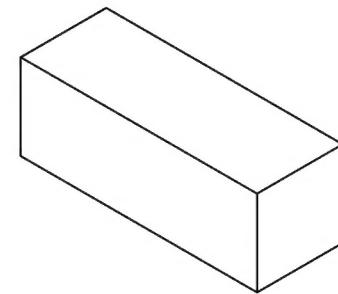
RETAINING RING

(-5)

DART AEROSPACE																										
TITLE																										
STAKING TOOL RETAINER																										
DWG NO. RBE105-40001W1-5																										
REV 1																										
<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 50%;">MATERIAL 4140/4142</td> <td style="width: 50%;">UNLESS OTHERWISE SPECIFIED</td> </tr> <tr> <td>HEAT RC 45-50</td> <td>DIMENSIONS ARE IN INCHES</td> </tr> <tr> <td>TREAT</td> <td>.XXX ± .005 FRACTIONS ± 1/8</td> </tr> <tr> <td>FINISH ZINC PLATE</td> <td>.XX ± .01 ANGLES ± 5°</td> </tr> <tr> <td>SPEC ASTM B633 TYPE I SC 2</td> <td>X ± .1 SURFACES = 125 ✓</td> </tr> <tr> <td>DRAWN BY: DUERFELDT</td> <td colspan="2">1. BREAK ALL SHARP EDGES .015 x 45° OR .015R</td> </tr> <tr> <td>CHECKED: CLOUGH</td> <td colspan="2">2. DIMENSIONAL LIMITS APPLY AFTER PLATING</td> </tr> <tr> <td>OPPS APPR: ANDERSON</td> <td colspan="2">3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009</td> </tr> <tr> <td>QA APPR: LINDSAY</td> <td colspan="2">USED ON MODEL</td> </tr> <tr> <td>APPROVED: GILBERT</td> <td colspan="2">SEE SHEET 1 NOTE 2</td> </tr> </table>		MATERIAL 4140/4142	UNLESS OTHERWISE SPECIFIED	HEAT RC 45-50	DIMENSIONS ARE IN INCHES	TREAT	.XXX ± .005 FRACTIONS ± 1/8	FINISH ZINC PLATE	.XX ± .01 ANGLES ± 5°	SPEC ASTM B633 TYPE I SC 2	X ± .1 SURFACES = 125 ✓	DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R		CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING		OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009		QA APPR: LINDSAY	USED ON MODEL		APPROVED: GILBERT	SEE SHEET 1 NOTE 2	
MATERIAL 4140/4142	UNLESS OTHERWISE SPECIFIED																									
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SPEC ASTM B633 TYPE I SC 2	X ± .1 SURFACES = 125 ✓																									
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R																									
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING																									
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009																									
QA APPR: LINDSAY	USED ON MODEL																									
APPROVED: GILBERT	SEE SHEET 1 NOTE 2																									
SCALE 1:1	DATE 1/19/2016																									
SHEET 4 OF 6																										

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REV		ECR		REVISIONS		
				DESCRIPTION		DATE
				INITIAL	APPROVED	



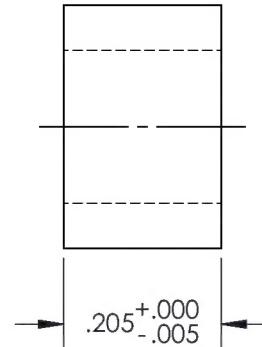
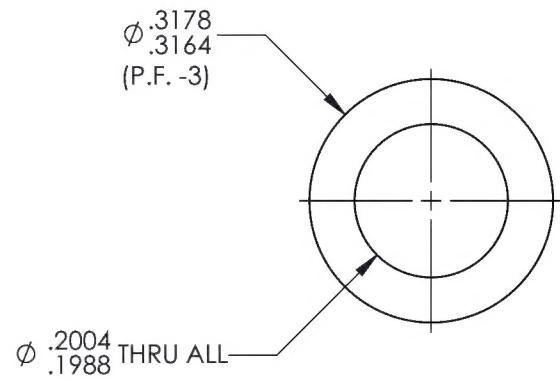
SLIDING PAD

(7)

TITLE		DWG NO.	
DART		AEROSPACE	
STAKING TOOL RETAINER		RBE105-40001W1-7	
REV		1	
MATERIAL S.S.		UNLESS OTHERWISE SPECIFIED	
HEAT		DIMENSIONS ARE IN INCHES	
TREAT		.XXX ± .005 FRACTIONS ± 1/8	
FINISH		.XX ± .01 ANGLES ± 5°	
SPEC		X ± .1 SURFACES = 125 ✓	
DRAWN BY: DUERFELDT		1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
CHECKED: CLOUGH		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
OPPS APPR: ANDERSON		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
QA APPR: LINDSAY		USED ON MODEL	
APPROVED: GILBERT		SEE SHEET 1 NOTE 2	
SCALE 8:1		DATE 1/19/2016	
		SHEET 5 OF 6	

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REV		ECR		REVISIONS		
				DESCRIPTION		DATE
				INITIAL	APPROVED	



(-9)

INSERT

	
TITLE	
MAT'L	NYLON
HEAT	UNLESS OTHERWISE SPECIFIED
TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± 5°
DRAWN BY:	CLOUGH
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
SCALE	4:1
DATE	7/12/2016
USED ON MODEL	
SEE SHEET 1 NOTE 2	
REV 1	

1. BREAK ALL SHARP EDGES
.015 x 45° OR .015R

2. DIMENSIONAL LIMITS APPLY
AFTER PLATING

3. INTERPRET DIM AND TOL PER
ASME Y14.5M-2009

USED ON MODEL

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only

Work Order: Part No. RBE101-40001W1-3/-5/-9/-11 NCR No.	DISPOSITION			AGAINST DEPARTMENT/PROCESS														
	Rework	Scrap	Use-as-is	Skid-tube	Machining	Thermoforming	Large Fab	Cross tube	Small Fab	Finishing	Composite	Water Jet	Prod. Eng. Coor.	Rec/Store/Packaging	Supplier	Engineering	Quality	Other
	Suspected Unapproved																	

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval <i>M. Lee</i> March 29, 2018
Description Work Order Deviation		Disposition	
- RBE101-40001W1-3/-5 can be manufactured from 17-4PH-H900 as an alternative material		- This deviation is acceptable.	Completed By
- If manufactured from SS, Heat treat is no longer applicable		- The drawings will be updated to reflect these changes.	Lead hand / Supervisor Approval Verification
- If manufactured from SS, Zinc plate is no longer applicable			
- RBE101-40001W1-9 material call-out is vague, manufacture from M-Delrin-R or MT-Nylon 6-R.		- The fit, form and function of the tool will be as originally intended.	
- Replace RSR Group Case 10137 with Black Pelican 1050 Case			QC / QA Coordinator Approval

Root Cause			FAULT CATEGORY														
Environment		No Re-verification	Pressure/Forced		Temperature/Cure										Power Loss/Surge		Positioned Wrong
Design		Operator	Bending		Set-up										Folio/Program		Outside Dimensions
Doc/Data		Offset/Setup	Centre Not Concentric		BOM/Route										Grain		Over/Under tolerance
Equip/Tooling		Supplier	Cracks		Broken/Damage/Defect										Weld		Part Incorrect
Handling/Pre		Training	Crimp/Kink/Ripple/Wave		Inspection Incomplete/Unqualified										Wrong Stock Pulled		Part Lost/Missing
Material	X	Use for Testing	Cuffs		Contamination										Out of Sequence		Part Moved
Internal Transport		Poor Information	Crushing		Countersink										Off-set		Drawing
Tribal Knowledge		Rushing	Heat Treat		Cut Too Short										Mislabeled		Finish
LOA		Product Improvement	Wave/Twist in Tube		Instructions Incomplete/Unclear										Fit/Function		Misread
Substation		Process Improvement	Marks/Chatter		Drill Holes										Misaligned/off center		Turning Sequence
Past Expiry Date		Manufacturing Process	OTHER :														
Misidentified	X	Past Due															